

Work Order ID 129615

February-20-15 7:57:08 AM

129615

Page 3

Item ID: D2661-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, RH, Fwd,Aft, Out
Start Date: 2/20/15 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 2/27/15 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>10:05</u> OVEN TEMPERATURE: <u>320°</u> FINISH TIME: <u>10:35</u>								
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>S401</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									

ET 15-03-04

8 MAR 04 2015 DAS 38 9-89

8 MAR 04 2015 DAS 08 9-89

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MLJ 15-03-05

15-3-5

Picklist Print

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Work Order ID: 129615

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Parent Item: D2661-2

D2661-2

Parent Item Name: Saddle, RH, Fwd,Aft, Out

Start Date: 2/20/15

Required Date: 2/27/15

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP: C00.11.01Removed P/O for Powder Coat - in house
processEC

IPP REV:D

REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	24.0000	1	8		DAS	
D6101-003									**	8		20	15-02-23
Saddle Billet, 7075												9-89	

Location

Loc Qty

Loc Code

MAT040

10

115091

10

MAT044

13

120394

13

MAT045

1

114314

1

128906

8

DART AEROSPACE LTD				Work Order: 129605	
Description: 206 Saddle, Outboard, Right side				Part Number: D2661-2	
Inspection Dwg: D2661 Rev: E DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.118	.120	.122	.119	.119
H	0.210	0.230		.223	.220	.220	.219	.219
I	0.615	0.685		.665	.665	.665	.665	.665
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.329	1.330	1.330	1.329	1.328
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.1417	1.1375	1.139	1.136	1.1355
O	0.100	0.180		.140	.140	.140	.140	.140
P	0.100	0.140		.117	.125	.126	.126	.126
Q	0.240	0.260		.250	.251	.252	.253	.253
R	0.677	0.697		.696	.686	.684	.685	.686
S	0.100	0.140		.116	.118	.119	.119	.120
T	1.565	1.585		1.5817	1.581	1.578	1.575	1.576
U	0.540	0.560		.543	.555	.555	.555	.555
V	0.912	0.932		.914	.924	.922	.922	.922
W	0.787	0.807		.797	.797	.797	.797	.797
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.499	.500	.499	.498	.498
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.507	.502	.502	.502	.502
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.237	.238	.237	.237	.237
AG	0.510	0.515		.510	.510	.510	.510	.510
AH	0.100	0.120		.110	.113	.112	.112	.112

DAS Accept/Reject

Measured by: 20 44 9.89 9.89 15/02/24	Date: 15-02-23
Audited by: DAS	Date: 15/02/25
Prototype Approval: 14 9.89	Date:

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

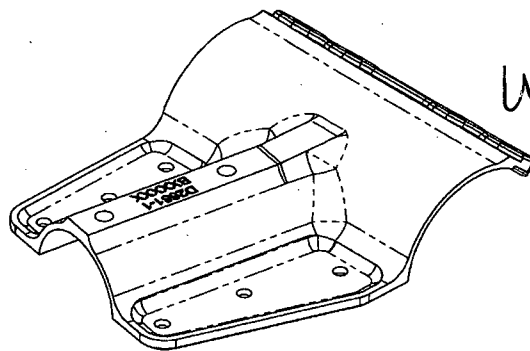
DART AEROSPACE LTD				Work Order: 179615	
Description: 206 Saddle, Outboard, Right side				Part Number: D2661-2	
Inspection Dwg: D2661 Rev: E DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

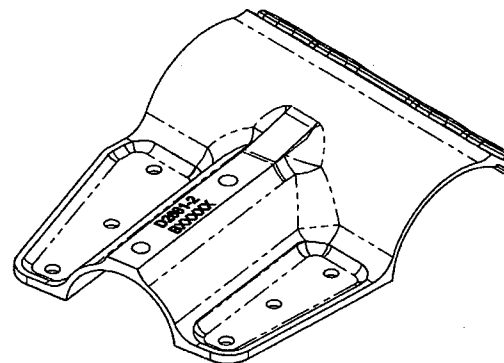
Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				6 #	7 #	8 #	4	5
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G	0.100	0.140		.118	.117	.118		
H	0.210	0.230		.218	.218	.218		
I	0.615	0.685		.665	.665	.665		
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M	0.470	0.530		.500	.500	.500		
N	1.125	1.145		1.135	1.1345	1.134		
O	0.100	0.180		.140	.140	.140		
P	0.100	0.140		.127	.128	.128		
Q	0.240	0.260		.254	.254	.254		
R	0.677	0.697		.685	.685	.687		
S	0.100	0.140		.120	.120	.120		
T	1.565	1.585		1.575	1.574	1.574		
U	0.540	0.560		.553	.553	.553		
V	0.912	0.932		.922	.925	.922		
W	0.787	0.807		.797	.794	.794		
X	5.990	6.010		6.000	6.000	6.000		
Y	4.995	5.005		5.000	5.000	5.000		
Z	0.490	0.510		.498	.499	.498		
AA	0.312	0.319		.314	.314	.314		
AB	0.990	1.010		1.000	1.000	1.000		
AC	1.245	1.255		1.250	1.250	1.250		
AD	0.490	0.510		.502	.502	.502		
AE	3.745	3.755		3.750	3.750	3.750		
AF	0.235	0.240		.237	.237	.237		
AG	0.510	0.515		.510	.510	.510		
AH	0.100	0.120		.112	.112	.112		
Accept/Reject								

Measured by: FK	Date: 15/02/14
Audited by: DAS	Date: 15/02/25
Prototype Approval: 14 9-89	Date:

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	



D2661-1 SADDLE, OUTSIDE, LH

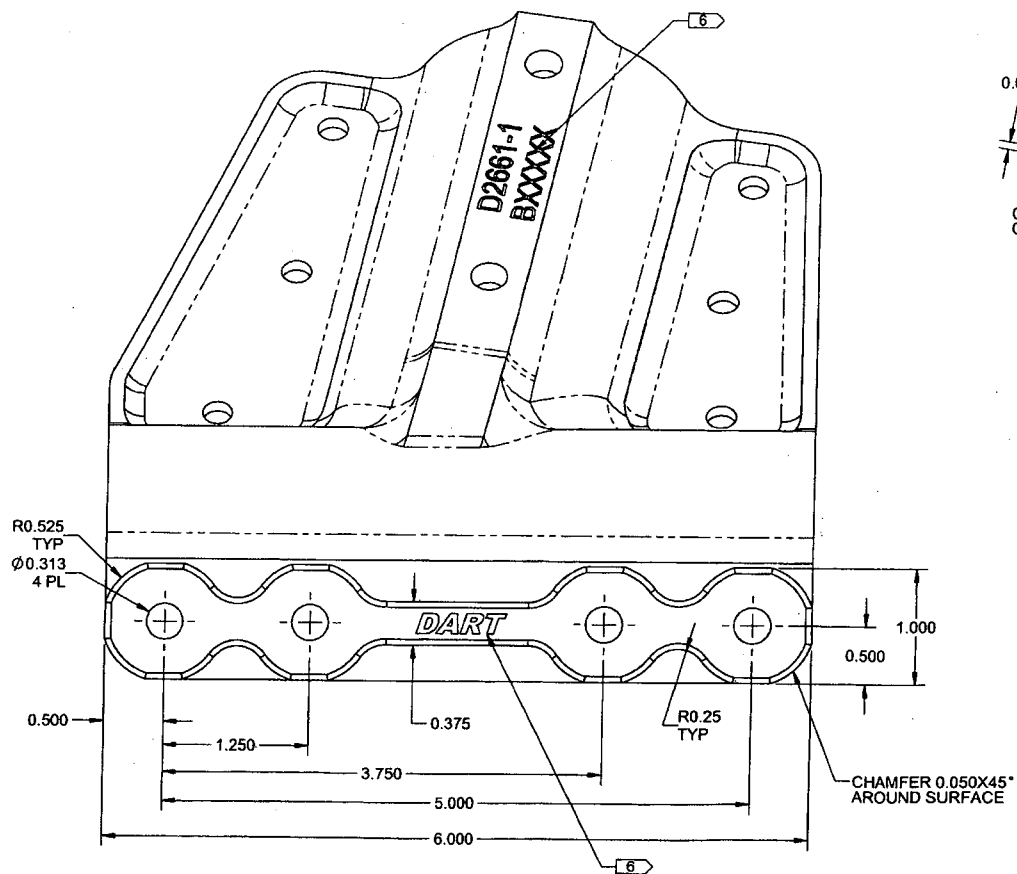


D2661-2 SADDLE, OUTSIDE, RH

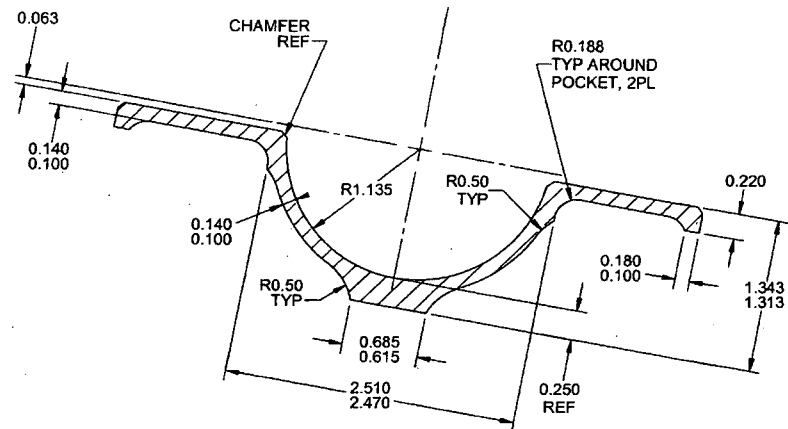
RELEASED
2011-11-16

REV.	DESCRIPTION	BY	DATE
E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B6-2, B8-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORPORATE DEO 9122, 9102, 9095	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25
DESIGN	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D2661 TITLE SADDLE, OUTSIDE SCALE NTS		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.	DATE 11.10.31 COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

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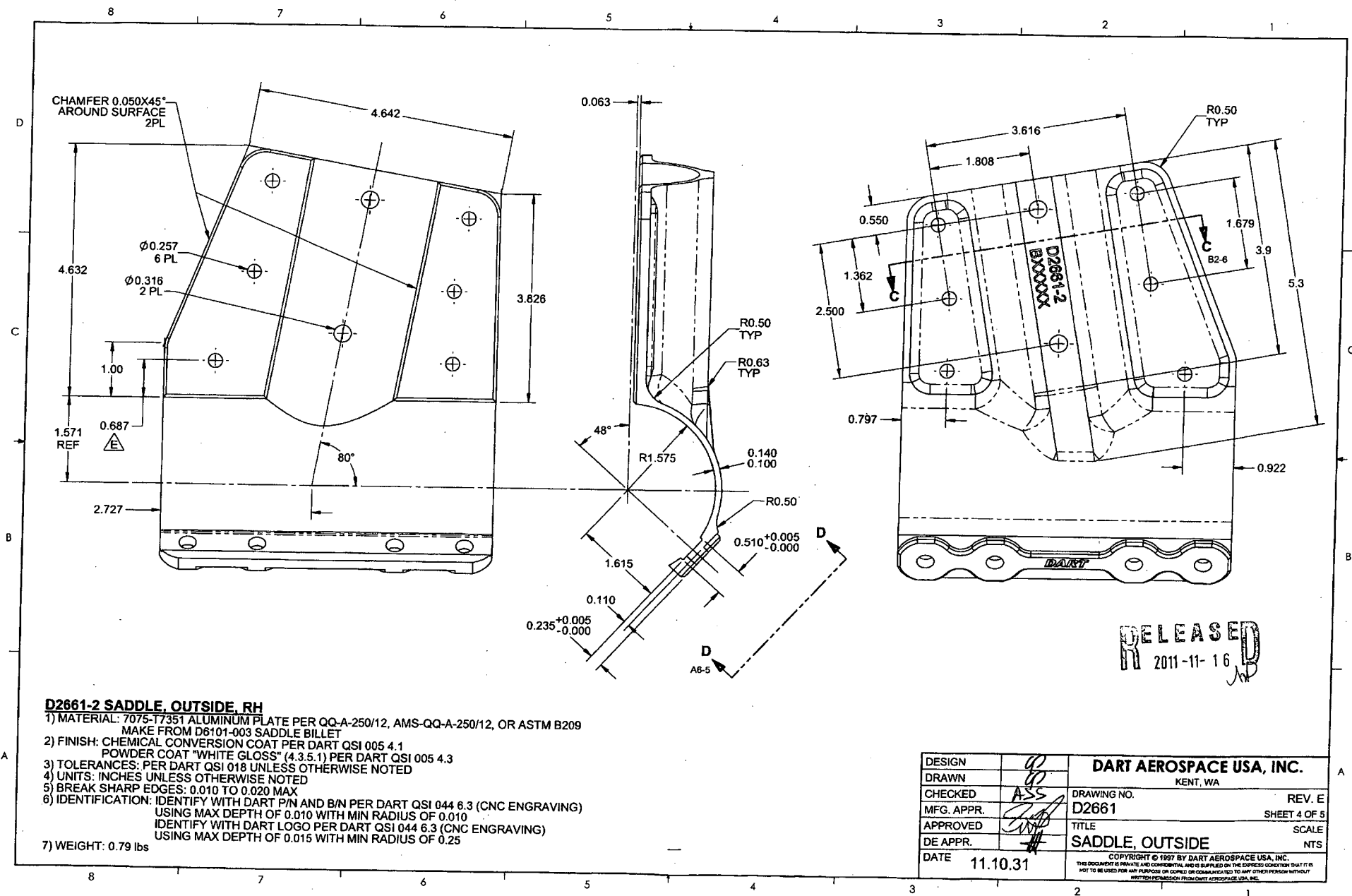
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VIEW ROTATED



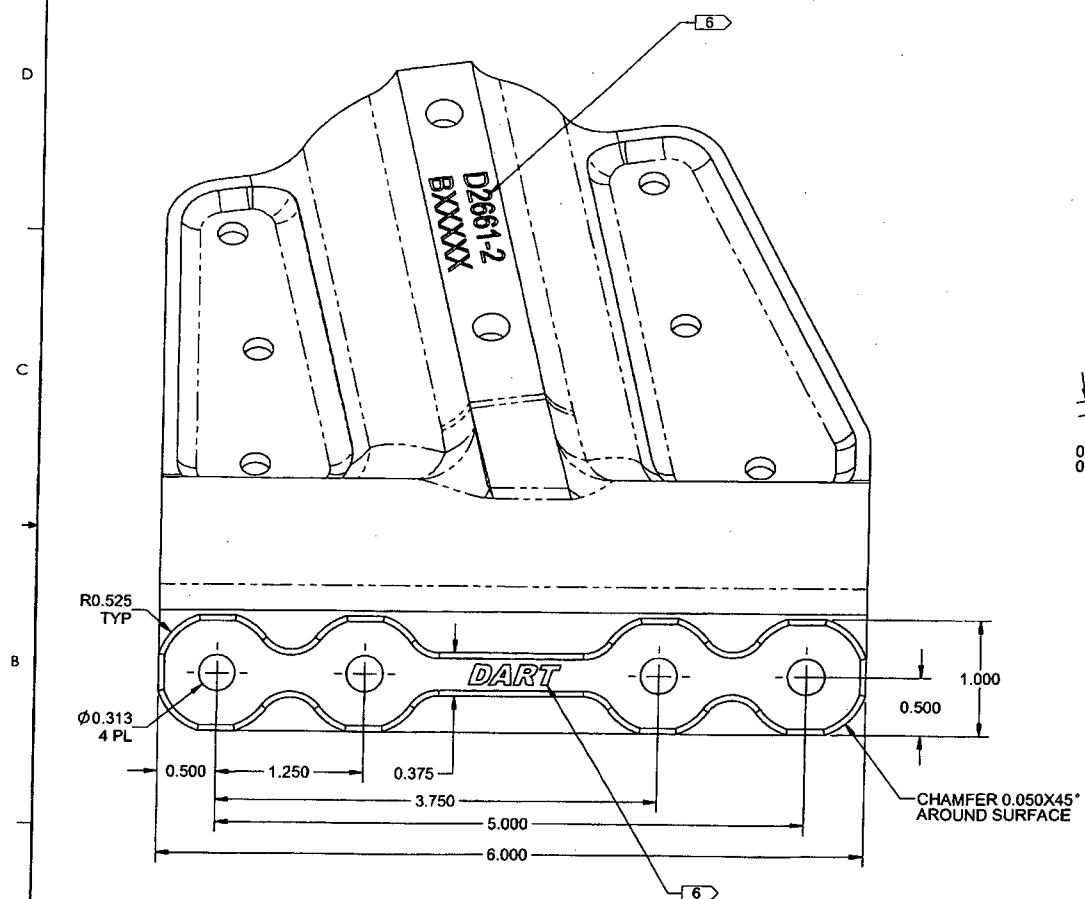
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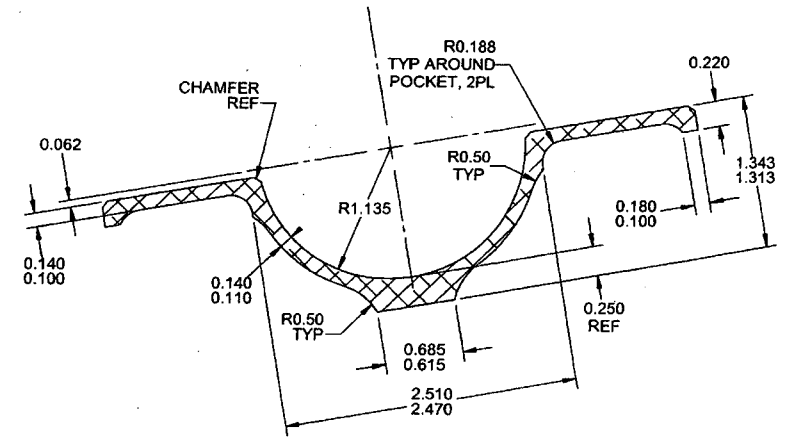
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D2661	REV. E
MFG. APPR.			SHEET 3 OF 5
APPROVED		TITLE SADDLE, OUTSIDE	SCALE
DE APPR.			NTS
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8 7 6 5 4 3 2 1



VIEW D-D B4-4
SCALE 1.5X
VIEW ROTATED



SECTION C-C C1-4
SCALE 1.5X

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2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN	<i>JP</i>	KENT, WA	
CHECKED	<i>ASS</i>	DRAWING NO. D2661	REV. E
MFG. APPR.	<i>[Signature]</i>	TITLE SADDLE, OUTSIDE	SHEET 5 OF 5
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DE APPR.	<i>[Signature]</i>	DATE 11.10.31	
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